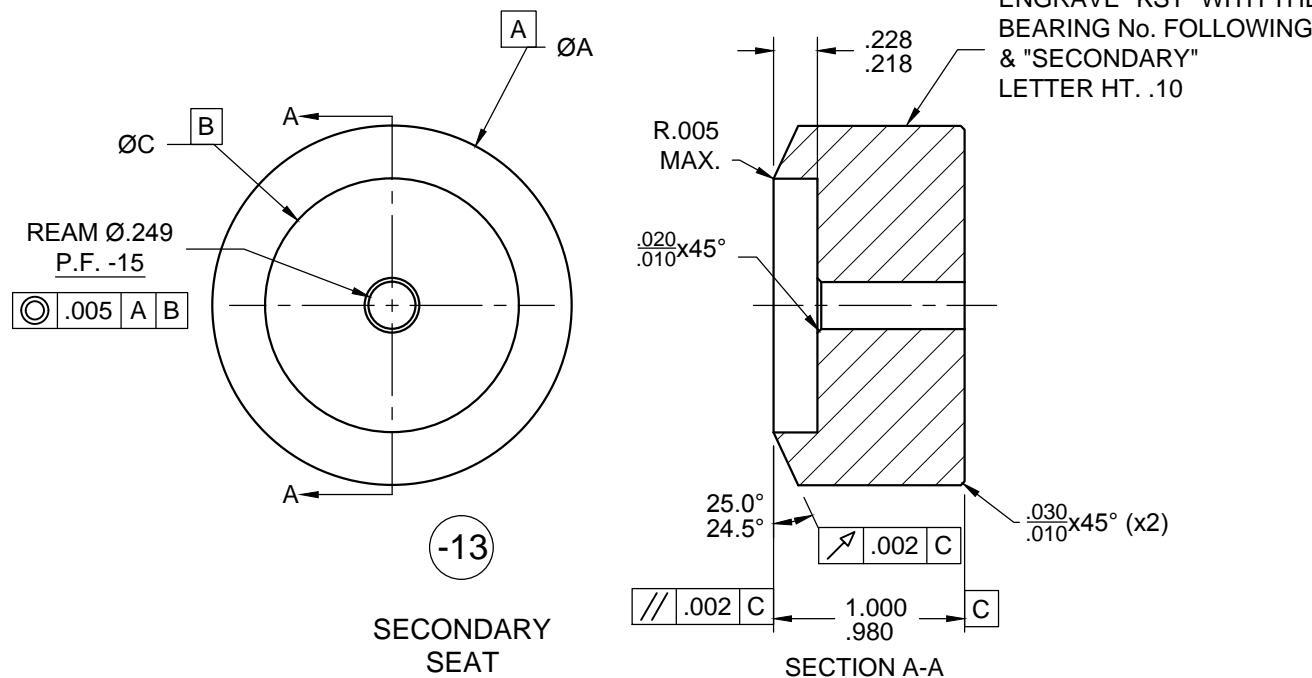


## NOTES

- #### 1. BREAK ALL SHARP CORNERS (.015/.03).

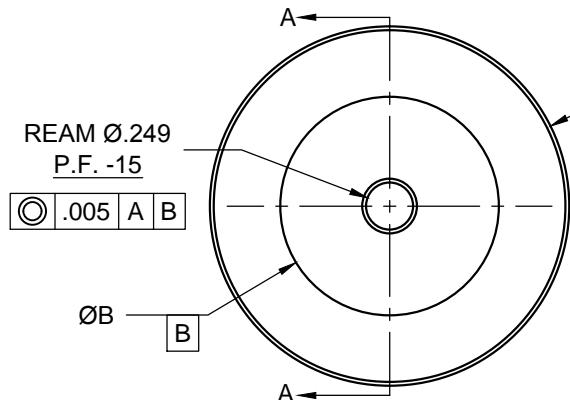
 RED BARN MACHINE	
TITLE	KSTER## SERIES
	SWAGING TOOL; LOCATING PIN
DWG NO.	TOOL# (see chart)-15
REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS $.XXX \pm .005$ FRACTIONS $\pm 1/32$ $.XX \pm .01$ ANGLES $\pm .5^\circ$ $X \pm .1$	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	8-14-08
SHEET 9 of 9	



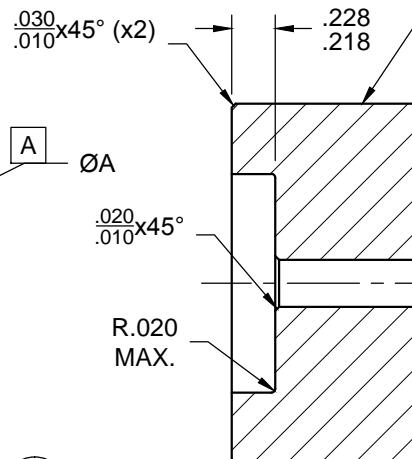
## NOTES

- #### **1. BREAK ALL SHARP CORNERS (.015/.03).**

 RED BARN MACHINE	
TITLE                    KSTER## SERIES	
SWAGING TOOL; SECONDARY SEAT	
DWG NO.	TOOL# (see chart)-13
REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS	
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± 5°
.X ± .1	
HEAT TREAT	
FINISH SPEC	
BLACK OXIDE	
DRAWN BY: PERRITT	
APPROVED	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	8-14-08
SHEET	8 of 9



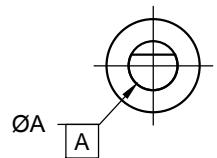
-11  
PRIMARY  
SEAT



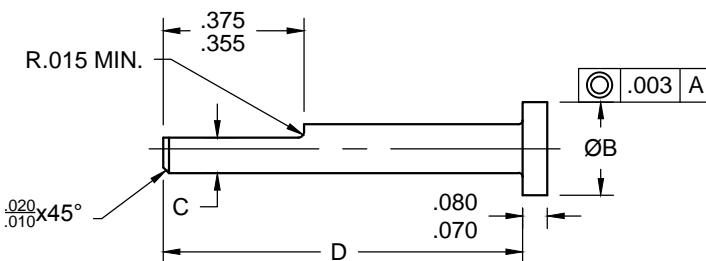
— ENGRAVE "KST" WITH THE  
BEARING No. FOLLOWING;  
& "PRIMARY"  
LETTER HT. .10

## NOTES

 RED BARN MACHINE	
TITLE	KSTER## SERIES SWAGING TOOL; PRIMARY SEAT
DWG NO.	TOOL# (see chart)-11
REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± .5° .X ± .1	
DRAWN BY: PERRITT	
APPROVED	
HEAT TREAT	
FINISH SPEC BLACK OXIDE	
USED ON BEARING	
SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. 015 R. 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	8-14-08
SHEET	7 of 9



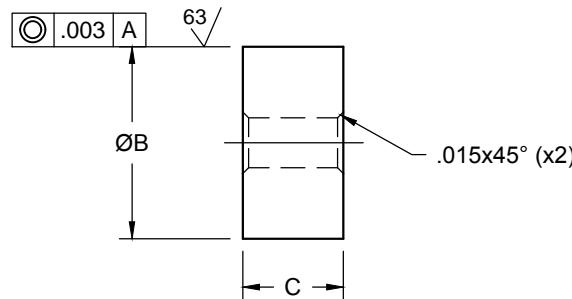
-9  
PIN



## NOTES

- #### **1. BREAK ALL SHARP CORNERS (.015/.03).**

 RED BARN MACHINE	
TITLE	KSTER## SERIES SWAGING TOOL; PIN
DWG NO.	TOOL# (see chart)-9
	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± 5° X ± 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY:	PERRITT
APPROVED	
HEAT TREAT	
FINISH SPEC	BLACK OXIDE
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	8-14-08
SHEET 6 of 9	



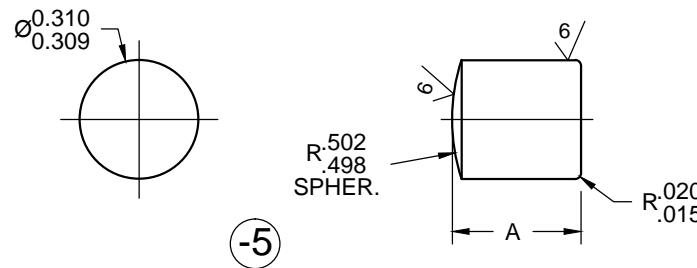
-7

## GUIDE

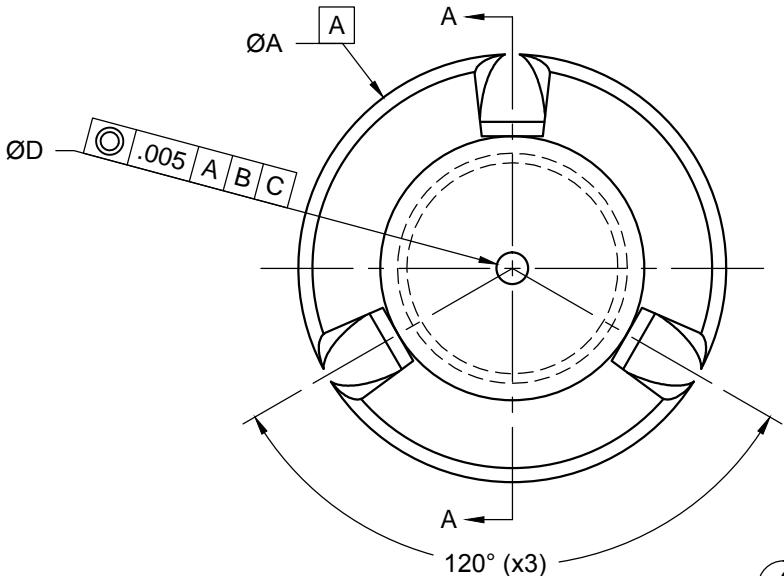
## NOTES

- #### **1. BREAK ALL SHARP CORNERS (.015/.03).**

 RED BARN MACHINE		
TITLE      KSTER## SERIES		
DWG NO.      SWAGING TOOL; GUIDE		
TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± .5° X ± .1		REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT
		APPROVED
		HEAT TREAT
		FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR-015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1
SCALE	NTS	DATE 8-14-08
		SHEET 5 of 9

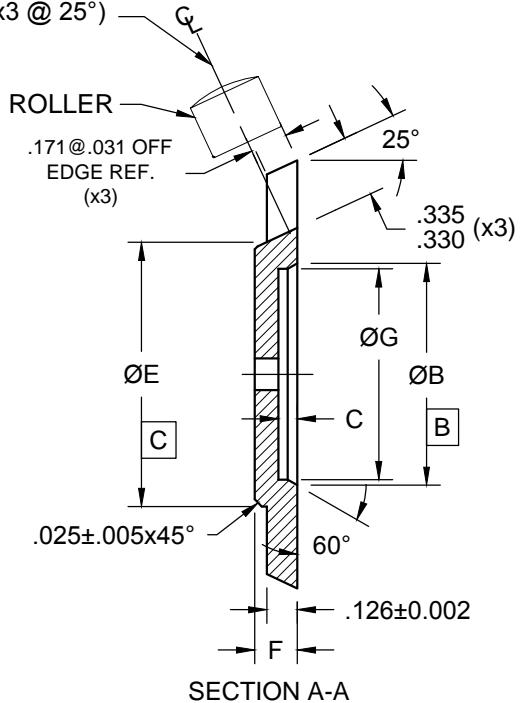


## ROLLER



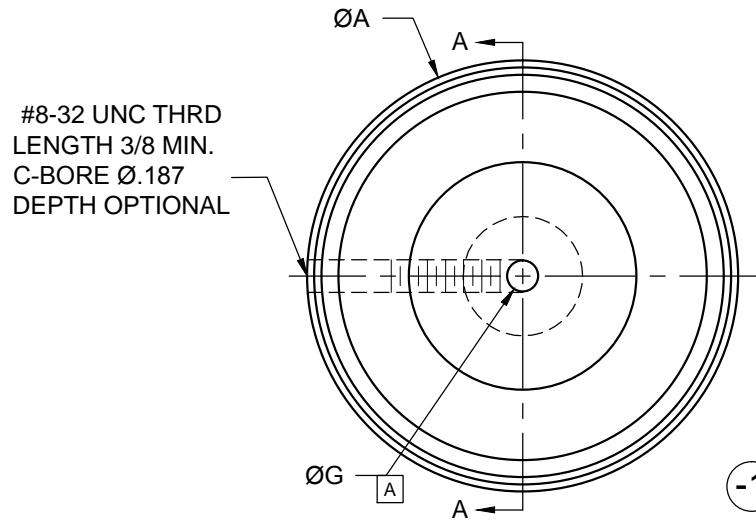
-3

## RETAINER

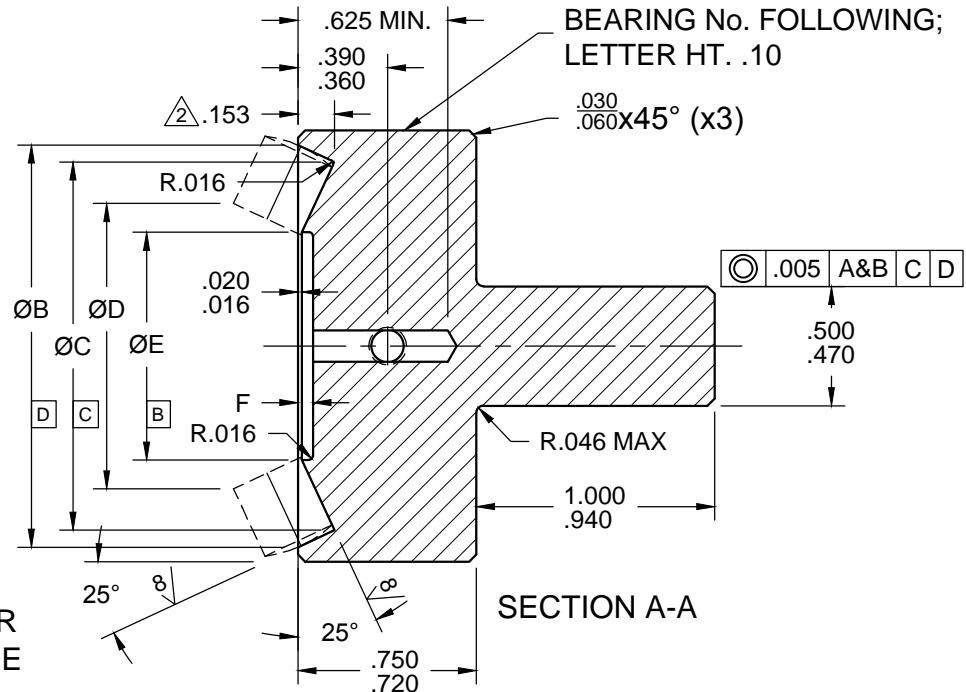


## NOTES

- ### 1. BREAK ALL SHARP CORNERS (.015/.03).



#8-32 UNC THRD  
LENGTH 3/8 MIN.  
C-BORE Ø.187  
DEPTH OPTIONAL



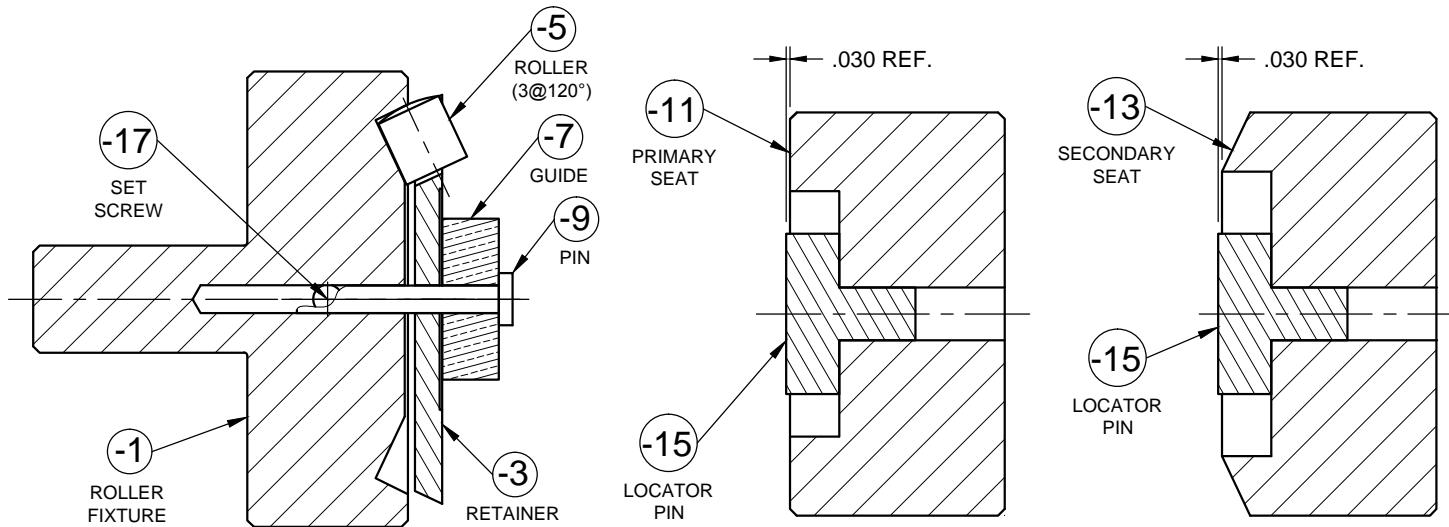
## ROLLER FIXTURE

**SECTION A-A**

## NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).  
2. DIMENSION TO BOTTOM OF R.016=.153;  
DIMENSION TO SHARP CORNER=.158.
  3. -1 BEARING RACE SURFACES MUST HAVE  
SMOOTH APPEARANCE, FREE FROM  
MACHINING MARKS AND GROOVES.
  4. DO FIRST ARTICLE INSPECTION  
BEFORE HEAT TREATING.

REV		DESCRIPTION		DATE	INITIAL	APPROVED
1		ADDED TOOL ERO4.		1/9/09	WP	-



#### NOTES

- 5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
- 5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
- FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.
- ENgrave AS SHOWN WITH "KST" & BEARING No.

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
BACB10ER04	KSTER04
BACB10ER05	KSTER05

RED BARN MACHINE	
TITLE KSTER## SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10ER## BEARINGS	
DWG NO. TOOL# (see chart above); ASSEMBLY	
REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 FRACTIONS ± 1/32	
XX ± .01 ANGLES ± 5°	
X ± .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES .015 x 45° PR.015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
HEAT TREAT LISTED PER ITEM	
FINISH SPEC LISTED PER ITEM	
DRAWN BY: PERRITT	
APPROVED	
USED ON BEARING	
SEE ABOVE	
SCALE	NTS
DATE	8-14-08
SHEET	1 of 9

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		SEE CHART	1	SECONDARY SEAT	SEE CHART	8
				LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

RB		RED BARN MACHINE		
TITLE				
DWG NO.		RE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX $\pm .005$ .XX $\pm .01$ .X $\pm .1$		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC USED ON MODEL		
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING				
SCALE	NTS	DATE	8-15-07	SHEET
				1 of

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY:	PERRITT	RB RED BARN MACHINE			
CHECKED					
HEAT					
TREAT					
FINISH					
SPEC					
USED ON MODEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				
?	TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± 5°				
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.015 x 45° PR. 0.015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING				
TITLE					
DWG NO.					
SCALE	NTS	DATE	1-28-06	SHEET	1 of 1

